

# Work Order ID 83506

**\*83506\***

Page 1

Thursday, April 19, 2012 10:24:16 AM

Item ID: D3202-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cover  
 Start Date: 4/19/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 4/27/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: R Date: 120419 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3202	Rev D					(14)			

100 0.00  
**\*100\***  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D3202  
 852.031 Dwg Rev: B  
 Prog Rev: \_\_\_\_\_

2-Debur if necessary  
 110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

B12-5-20

B12-5-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83506

\*83506\*

Page 2

Thursday, April 19, 2012 10:24:17 AM

Item ID: D3202-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cover  
 Start Date: 4/19/2012 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 4/27/2012 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 *120* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				(4/19)			
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130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				14			7/6/12 5:22
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140 *140* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 2:20 OVEN TEMPERATURE: 320 °F FINISH TIME: 2:50	0.00 0.00				14X			12/5/22
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M 117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83506

\*83506\*

Page 3

Thursday, April 19, 2012 10:24:17 AM

Item ID: D3202-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cover  
 Start Date: 4/19/2012 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 4/27/2012 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Insp Part Finish	0.00							
*150*						14	φ		12/5/22
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location	0.00							
*160*						N			12/5/28
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
*170*									12/5/29
QC	Memo	0.00							
Quality Control									

12/5/28  
 12/5/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Thursday, April 19, 2012 10:24:30 AM

Work Order ID: 83506

\*83506\*

Parent Item: D3202-1

\*D3202-1\*

Parent Item Name: Cover

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:B No Longuer Made In House 05-11-06 JLM  
 IPP Rev:C Now on Waterjet 07-04-18 JLM  
 IPP Rev:D chg to revC as per dwg 08-04-21 DD verified  
 by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	130.8000	1.551	19.59158	22.		

\*M5052H32S 032\*

5052-H32 .032 Sheet

\*\*

B 12-5-20

Location

Loc Qty

Loc Code

MAT022

130.8

112664

10.4

115638

12

116657

20.5

117798

20.9

121030

34

121040

33

116657 X 7 = 11.

121030 X 7 = 11.

(A)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

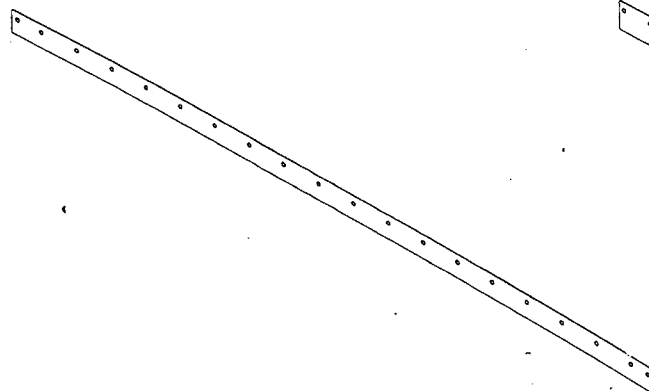
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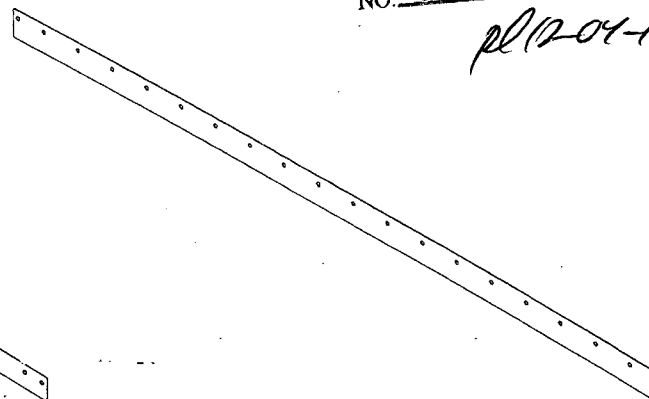
**NOTE:** Date & initial all entries

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83506

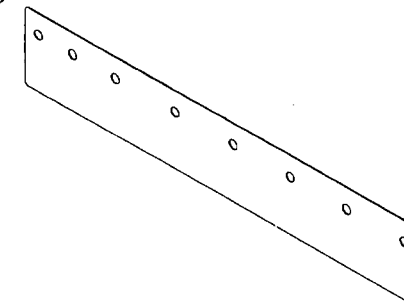
*PL 12-04-19*



**D3202-1 COVER**



**D3202-3 COVER  
(COMPOSITE DOOR)**



**D3202-5 COVER  
(HINGE PANEL DOOR MOD)**



**RELEASED**  
*02-11-10-11*

**NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1  
0.61 lbs APPROX FOR -3  
0.18 lbs APPROX FOR -5

D	ADD -5 FOR HINGE PANEL DOOR MOD.	AJS	08.11.03
C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART, NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3202	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	08.11.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

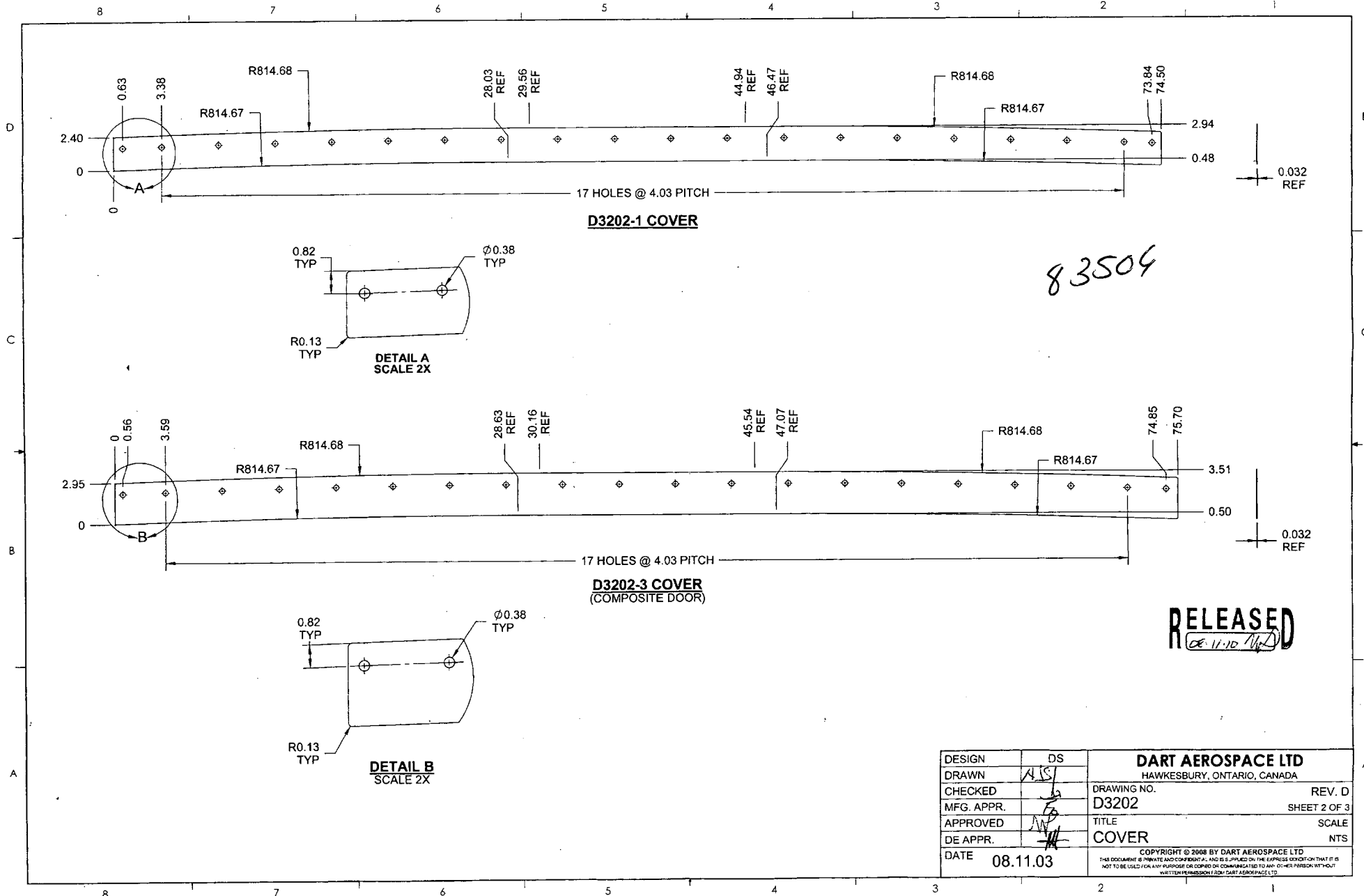
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DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	<b>D3202</b>	SHEET 2 OF 3
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DE APPR.	MP	<b>COVER</b>	NTS
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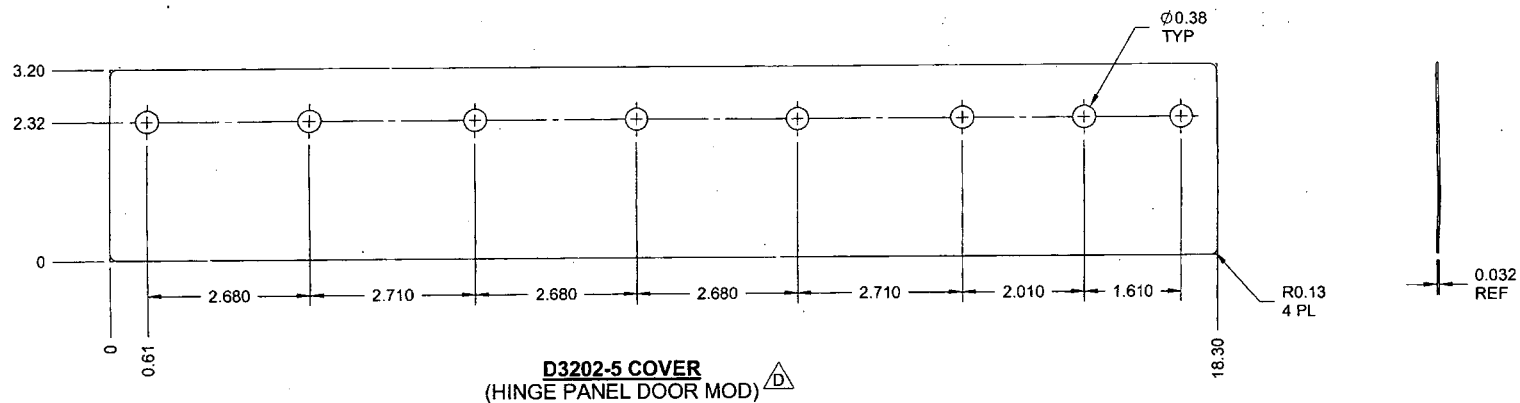
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



83504

RELEASED  
08.11.03

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
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MFG. APPR.		D3202	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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**NOTE:** Date & initial all entries